

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009350**Date Inspected:** 23-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 01 (Cross Beam # 15)

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Side Plate. The weld designations reviewed are as follows:

(CB202B-015-001,003,004)

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Side Plate. The weld designations reviewed are as follows:

(CB202B-015-001,003,004)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 02

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Flux Cored Arc Welding Process:

Welding of weld joint –022,023 located on PCMK FB3089-001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –021,022 located on PCMK FB3026-001. Welder is identified as 215676. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –008,035 located on PCMK FB3079-001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –001,002 located on PCMK LD007-012. Welder is identified as 206623. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint –007,008 located on PCMK LD001-047. Welder is identified as 055491. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint –001,002 located on PCMK LD003-058. Welder is identified as 044801. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –011 located on PCMK LD007-013. Welder is identified as 208035. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –011 located on PCMK LD009-010. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for

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your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Whitehead,Lonnie

QA Reviewer